

Work Order ID 76340

76340

November-09-11 8:39:35 AM

Page 1

Item ID: D3552-23

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Door Prop

Stop

NS2

Start Date: 09/11/2011 Start Qty: 20.00

20

Cust Item ID:

Required Date: 18/11/2011 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/11/09

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
----------	--------------	--

D3552

I

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Issue P/O: 13419
Purchase Part Number: B6-190-475-070N
Supplier: LS Technologies
Certificate of conformity is required

11/11/09
20

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

R. Müller (2)

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Quality Control

Memo

0.00

Test for correct pressure

Sululuf

coaster
+20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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N900040100

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Cust Item ID:

Required Date: 18/11/2011 Req'd Qty: 20.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location

ST 272A

0.00

130

Packaging

Packaging

Memo

0.00

11/11/14

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.00

11/11/15 J

11/11/15

20

W/O:		WORK ORDER CHANGES					
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Picklist Print

November-09-11 8:39:39 AM

Page 1

Work Order ID: 76340

76340

Parent Item: D3552-23

D3552-23

Parent Item Name: Door Prop

Start Date: 09/11/2011

Required Date: 18/11/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A 11.04.07 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
B6-190-475-070N		Purchased		No			Each	0.0000		20			
B6-190-475-070N									**			<i>14/11/11</i>	<i>(20)</i>

Door Prop

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

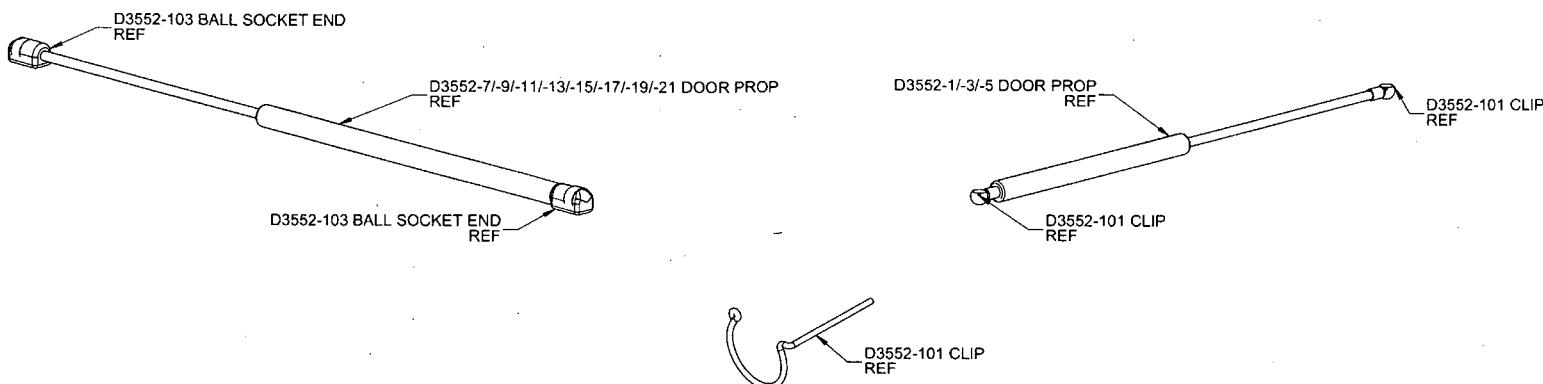
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING



RELEASED
2011-10-13
MP

SPECIFICATION
 RETURN TO
 ENGINEERING
UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO 76340 M.C.J
 11/11/09

I	ADD P/N D3552-23	RF	11.10.11
H	ADD P/N D3552-21	DC	11.03.10
G	FOR -15, FORCE:300/67.4 WAS 400/89.9, SUPPLIER P/N B8-154-387-300N WAS B8-154-387-400N, FOR -17, STROKE: 139/5.47 WAS 160/6.30, EXT LG: 386/15.2 WAS 407/16.0, SUPPLIER P/N B8-154-387-156N WAS B8-167-408-156N	JPH	10.11.01
F	ADD P/N D3552-15/-17/-19 AND ALTERNATE SUPPLIER	JPH	10.07.27
E	ADD P/N D3552-13 ZN B8-1, A8-1, D6-1, CHANGE NAME FROM "GAS SPRING" TO "DOOR PROP" THROUGH OUT DWG	HS	10.02.03
D	ADD P/N D3552-101 ZN D6-1, C7-1, C1-1 AND D3552-103 ZN D1-1 AND C2-1 AND ZN B8-1; ADD NOTE REGARDING D3552-101 AND D3552-103 COMPATIBILITY ZN A8-1	HS	09.04.02
C	ADD D3552-11 AND CONVERSIONS FOR INSPECTION; UPDATE P/N FOR D3552-7	LE	07.06.01
B	ADD D3552-7/-9; UPDATE DESC. D3552-1/-3/-5	LE	06.10.24
A	NEW ISSUE	LE	06.09.15
REV	DESCRIPTION	BY	DATE
DESIGN	<i>LE</i>	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>LE</i>	DRAWING NO.	REV. I
MFG. APPR.	<i>LE</i>	D3552	SHEET 1 OF 2
APPROVED	<i>LE</i>	TITLE	SCALE
DE APPR.	<i>LE</i>	DOOR PROP	NTS
DATE	11.10.11	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE UNLESS OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

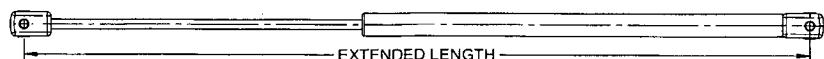
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

26340

8 7 6 5 4 3 2 1



DART PART NUMBER	DESCRIPTION	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	FORCE (N/lb)	END FITTING	MATERIAL	SUPPLIER	SUPPLIER PART NUMBER OR MODEL NUMBER	ALTERNATE SUPPLIER	ALTERNATE SUPPLIER P/N OR MODEL NUMBER
D3552-1	DOOR PROP	220/8.66	530/20.6	70/15.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-220-530-070N	N/A	N/A
D3552-3	DOOR PROP	200/7.87	490/19.3	200/45.0	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-200-490-200N	N/A	N/A
D3552-5	DOOR PROP	175/6.89	430/16.9	150/33.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-175-430-150N	N/A	N/A
D3552-7	DOOR PROP	220/8.66	530/20.9	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-220-530-070N	N/A	N/A
D3552-9	DOOR PROP	200/7.87	490/19.3	200/45.0	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-200-490-200N	N/A	N/A
D3552-11	DOOR PROP	240/9.45	575/22.6	150/33.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-240-575-150N	N/A	N/A
D3552-13	DOOR PROP	220/8.66	530/20.9	140/31.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-220-530-140N	N/A	N/A
D3552-15	DOOR PROP	139/5.47	386/15.2	300/67.4	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-300N	SUSPA, Inc.	16-2-210-139-A101-B101-400N
D3552-17	DOOR PROP	139/5.47	386/15.2	156/35.1	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-156N	SUSPA, Inc.	16-2-210-160-A101-B101-156N
D3552-19	DOOR PROP	139/5.47	386/15.2	60/13.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-060N	SUSPA, Inc.	16-2-210-139-A101-B101-060N
D3552-21	DOOR PROP	167/6.57	410/16.1	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-167-410-070N	N/A	N/A
D3552-23	DOOR PROP	190/7.48	475/18.7	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-190-475-070N	N/A	N/A
1 D3552-103	BALL SOCKET END	N/A	N/A	N/A	N/A	NYLON	LS TECHNOLOGIES	B10	N/A	N/A
2 D3552-101	CLIP	N/A	N/A	N/A	N/A	CARBON STEEL	LS TECHNOLOGIES	C9	N/A	N/A

D3552-X DOOR PROP

RELEASED
2011-10-13
W

NOTES:
 1) IDENTIFICATION: IDENTIFY PER QSI 044.6.2
 2) D3552-101 CLIP IS ONLY COMPATIBLE WITH D3552-1/-3/-5 DOOR PROPS
 3) D3552-103 BALL SOCKET END IS ONLY COMPATIBLE WITH D3552-7/-9/-11/-13/-15/-17/-19/-21 DOOR PROPS

DESIGN	CE	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	E		
MFG. APPR.	W	REV. 1	
APPROVED	W	D3552	SHEET 2 OF 2
DE APPR.	W	TITLE	SCALE
DATE	11.10.11	DOOR PROP	NTS

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8 7 6 5 4 3 2 1

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NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO15419**

Purchase Order Date 11/9/2011

PO Print Date 11/9/2011

Page Number 1 of 1

Order From : VC-LST0001

LS TECHNOLOGIES INC.
303-103 STREET
SASKATOON, SK S7N 1Y9
CA

Contact Name	Buyer	Brigitte Golden
Vendor Phone	Requisition Nbr	
Vendor Fax	Tax Resale Nbr	10127-2607
Vendor Account Nbr	Terms	Net 30
	Currency	CAD
	FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	B6-190-475-070N	Door Prop	11/11/2011 Yes	20.00 Each		\$32.5000	\$650.00

Special Inst: As per Dwg:D3552 Rev: I B76340

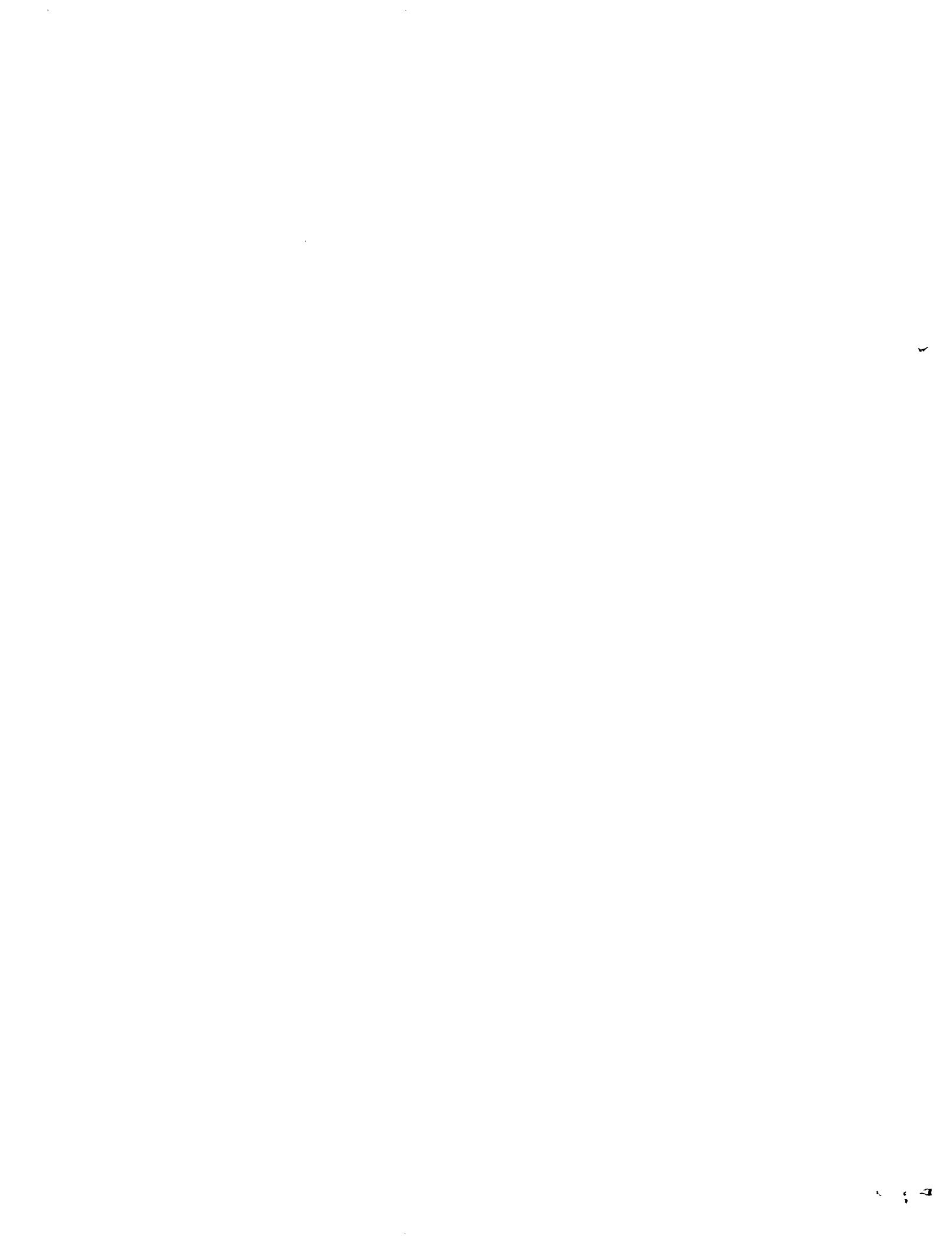
PO Total: \$650.00

No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 11/9/2011



LS Technologies Canada Inc.

303 - 103 Street
Saskatoon, SK Canada
S7N 1Y9

Packing Slip

Date	Invoice #
09/11/2011	7913

Name / Address
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship To
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

P.O. No.	Ship	Via	FOB	Project
PO15419	03/11/2011	Fed-Ex		

Qty	Description
20	B6-190-475-070N Door Prop D3552-23 Shipping Via FED EX Tracking # 797719874632





303 – 103rd Street, Saskatoon, Saskatchewan, Canada S7N 1Y9
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

20 Units; B6-190-475-070N Door Prop (D3552-23) Carbon Steel Gas Spring

Country of Manufacture: Canada
Date of Manufacture : November 2011
This product is ROHS compliant.

We certify no mercury was used in the manufacture of this order.

Purchase Order # 15419
Invoice # 7913

S. Ulrich

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to read "Nolan Fehr".

Nolan Fehr
Manager

